

Work Order ID 85483

85483

Page 1

Item ID: D2500-1-190

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ext'n - 'I' Beam Tube 4"

Start Date: 08/06/2012 Start Qty: 90.00

90

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 90.00

90

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/08 Tooling: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2500	Rev H
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100	PURCHASING	0.00
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100

Purchasing

Purchasing

Memo

Issue P/O: 17180

- a) Extrude as per Dwg D2500
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 190" long
- g) Bon L. Canada Inc. tool # 897105
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

110	Receive & Inspect for Damage & Mat'l Certs	0.00
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110

Packaging

Packaging

Memo

Ensure material certification is attached

CL 12/06/11 90

12/8/27 92

Work Order ID 85483

85483

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June-08-12 10:13:14 AM

Item ID: D2500-1-190

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Ext'n - I' Beam Tube 4"

Stop ***NS2***

Start Date: 08/06/2012 Start Qty: 90.00

90

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 90.00

90

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC		0.00							
Quality Control	Memo Check Pull test per Dwg D2500 for compliance page attached. Check hardness with Webster tester								
130	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
130									
Packaging	* Pull Qty 220 for QC inspection	0.00							
Packaging	Memo								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC		0.00							
Quality Control	Memo								

12/7/48

12024

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> </div> <div> Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Offset/Setup											
Other											
Process											
Supplier											
Training											
Unauthorized											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____

Picklist Print

June-08-12 10:13:18 AM

Page 1

Work Order ID: 85483

85483

Parent Item: D2500-1-190

D2500-1-190

Parent Item Name: Ext'n -1' Beam Tube 4"

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 90.00

Required Qty: 90.00

Comments: IPP: G 02.09.05 Added DSK 066 KJ/RF
IPP: H 07.07.06 rev G dwg EC IPP Rev:1 as per
dwg revH DD 10.02.23 verified byEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-190P		Purchased	No			110	Each	0.0000	1	90			

D2500-1-190P

Ext'n -1' Beam Tube 4"

**

LC 14/6/12 92

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
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Equip/Tooling <input type="checkbox"/>																											
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SPECIFICATION CONTROL DRAWING

D2500-1-XXX EXTRUSION & D2500-3-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: D2500-1 = 0.143 lb/in, D2500-3 = 0.066 lb/in

8) FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG). D2500-1 EXTRUSION MANUFACTURED FROM:

- A) BON L DIE # 897105 -> PREFERRED
- B) CARADON MIDEAST DIE # PAH-28030
- C) CARADON MTL DIE # MH-18868

9) FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG). D2500-3 EXTRUSION MANUFACTURED FROM:

- A) CARADON INDALEX DIE # MS-18867

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 85483 MLJ

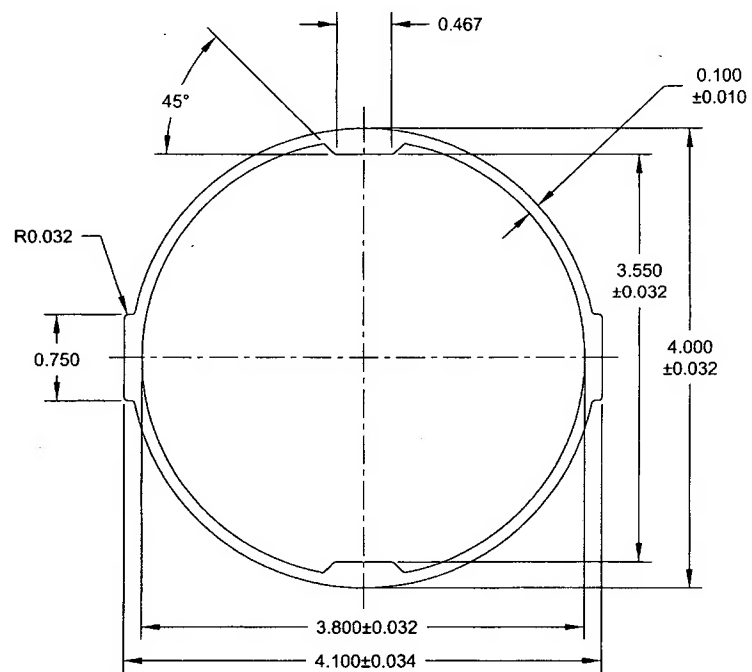
12/06/08

RELEASED
2010-02-02
MP

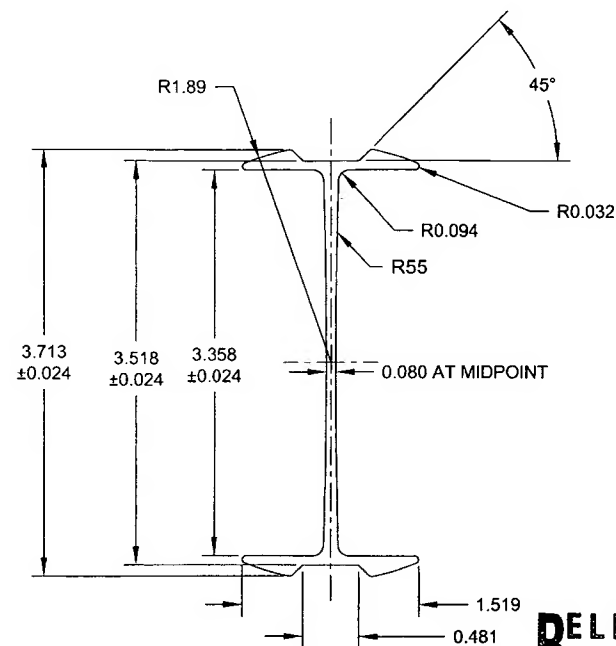
H	REDRAW & REFORMAT DWG; CORRECT BON L DIE # TYPO (ZN B8-1), ADD AMS & ASTM MAT'L OPTION (ZN D8-1), TOLERANCES NOW PER CARADON DWG (SHT 2)	CP	09.07.16
G	ADD DIE NUMBERS & 'DIMS IN INCHES' NOTES	PH	07.04.17
F	CHANGE MAT. TO 6061-T6	DS	97.09.29
E	CHANGE MATERIAL TEMPER	DS	96.10.24
D	ADD MATERIAL PROPERTIES	DS	96.10.07
C	ADD D2500-3 WEB	BW	96.04.26
B	CHANGE INTERNAL WEB	DS	96.03.24
A	NEW ISSUE	DS	96.03.19
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. H D2500 SHEET 1 OF 2 TITLE SCALE EXTRUSION NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.07.16		

8 7 6 5 4 3 2 1

25483



D2500-1



D2500-3

RELEASED
2010-07-02
MAP

DESIGN	4	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BT	DRAWING NO.	REV. H
MFG. APPR.	W	D2500	SHEET 2 OF 2
APPROVED	W	TITLE	SCALE
DE APPR.	W	EXTRUSION	NTS
DATE	09.07.16	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

ACCT# 46024

INVOICING AND COMPANY LOCATION

SHIPPING MANIFEST

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

MANIFEST DATE / DATE DU BODEREAU
06-26-12

MANIFEST NUMBER / N° DE BODEREAU
006402

SALES ORDER NUMBER / N° DE COM
106149

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PIC	WILRIDE	042		G.ATTENBOROU
	JOB / FICHER		FIELD SALES REP / REP REGIONAL DES VENTES	CUST SERVICE REP / REP. SERVICE CLIENTELE
	CARRIER / TRANSPORTEUR WILRIDE		G.ATTENBOROU	DLB

CUSTOMER ID / ID DU
CLIENT

46024

ORDER DATE / DE LA
COM

06/11/12

CUSTOMER PO NUMBER / CLIENT PO Nombre

17180

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

006402

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	2,413	LB		DAA-897105-2	6061 T6		4	2,460	2,355	LB	
	1,094	KG		D2500-1-190	190.0000 IN			1,116	1,068	KG	
	90	PC			Cut(+): 0.1180 Cut(-): 0.0000 Min: -10 % Max: 10 %				92	PC	
						813773 / 146008	1	615	589		23 PC
						813773 / 146009	1	615	589		23 PC
						813773 / 146010	1	615	589		23 PC
						813773 / 146011	1	615	589		23 PC

92

4 BUNDLES

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

Page 1

4	2,460	2,355	LB
	1,116	1,068	KG
		92	PC
TOTALS			

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER

signature
aluminum
CANADA INC.

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
06/24/2012	5285844	106149	1
Cust PO	B/L No.	Lot	Date
17180	006402	813773	06/26/12

Sold To		Ship To	
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA		46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	
Item No	Part No	Item Description	Cust Part
001	DAA-897105-2	190" Mill 6061 T6	D2500-1-190
Gross Weight	2,460 LBS		
Net Qty	2,355 LBS		92 PCS
Specification			Die Desc
AMS QQA 200/9 + ASTM B221-08			

Mechanical Tests:

Tensile	Yield	% Elongation	Conductivity	HRE
MPA / KSI	MPA / KSI			
329.0 / 47.7	293.8 / 42.6	9.3	N/A	91

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.63	0.27	0.23	0.06	0.87	0.07	0.11	0.02	0.01

8/17/06/27

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta, Director of Quality Signature Aluminum Canada Inc

PROFORMA INVOICE EXPORTER / SELLER SIGNATURE ALUMINUM CANADA 1850 CLEMENTS ROAD PICKERING ON CANADA L1W 3R8		CONSIGNEE DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		CARRIER REF. NO.	DATE ENTERED 26/06/12	SHIPPER REF. NO. 006402	EXPORT PAPER NO.
FROM PICKERING Ontario CANADA LOCAL POINT OF LANDING		PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		COUNTRY OF FINAL DESTINATION CANADA		COUNTRY OF ORIGIN CANADA	
				TERMS OF DELIVERY AND PAYMENT DDP PPD DELIVERY DUTY PAID BY SELLER			
LOCAL AND EXPORTING CARRIER: WILRIDE				VEHICLE CONTAINER NO. : WILRIDE			

PKGS/BUNDLES	PIECES	DESCRIPTION		MKK CDE	NET WEIGHT	UNIT PRICE	INVOICE VALUE
4	92	Aluminum Alloyed Hollow Profile	7604210000	1	2,355 LBS	3.27/ LB	7,704.00

		TOTAL:		7,704.00
WOOD PACKAGING MATERIAL IS COMPRISED ENTIRELY OF CANADIAN / U.S. MATERIAL BLANKET CERTIFICATE ON FILE WITH FEDEX TRADE NETWORKS			SHIPPING WGT. 2,460 LBS	VALUE CURRENCY CA
CUSTOMER ORDER NUMBER		SELLER ORDER NUMBER		
PORT OF ENTRY		PORT OF EXIT		
US CUSTOM BROKER : FEDEX TRADE NETWORKS		ESTIMATED FREIGHT CHARGES TO DESTINATION		
RETURN ADDRESS SIGNATURE ALUMINUM CANADA 1850 CLEMENTS ROAD PICKERING ON CANADA L1W 3R8		DATE PRINTED: 06/26/12 PICKERING Ontario CANADA Signature:		

COUNTRY OF ORIGIN MARKING CODE TABLE :
 1 = PRODUCT EXEMPT AS PER THE "J" LIST
 2 = EACH ITEM MARKED WITH COUNTRY OF ORIGIN
 3 = PRODUCT SOLD TO THE ULTIMATE PURCHASER IN BULK, LETTER FROM CUSTOMER WILL BE SUPPLIED UPON REQUEST
 4 = INDIVIDUAL ITEM PACKAGING STATES COUNTRY OF ORIGIN